

Work Order ID 84798

84798

Page 1

May-23-12 11:30:02 AM

Item ID: D3838-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly (Basket Lid, RH)
 Start Date: 23/05/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 29/05/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3838	Rev A

100 Large Fab 0.00

100

Large Fab

Large Fab

Memo

0.00
 1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: M 122130

5- c/sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: M 122130

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

SAD 12-11-08

CC 12-11-19 (3x)

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(3)	12-11-21		DAS 09 2-89
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(3)	12-11-21		DAS 09 2-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Memo	0.00 0.00				CC	12-11-21		(3)

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May-23-12 11:30:02 AM

Item ID: D3838-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 23/05/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/11/22 JJ

MRF
12-11-21

Picklist Print

May-23-12 11:30:05 AM

Page 1

Work Order ID: 84798

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Parent Item: D3838-042

D3838-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 23/05/2012

Required Date: 29/05/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	352.0000	1	3			

D3759-1

Bushing

**

CC 12-11-19

Location

Loc Qty

Loc Code

WA

202

B 89780 →

(3)

79213

1

83464

201

WA005

150

66489

1

82785

149

M304TS0.750W.065

Purchased

No

100

f

436.5616

1.0317

3.258

M304TS0 750W 065

**

SAD

12-11-08

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT017

384.1237042

120267

53.7325342

120633

330.39117

MAT018

45.78049

121170

4.78049

7636

41

WA007

0.5907428

116763

0.5907428

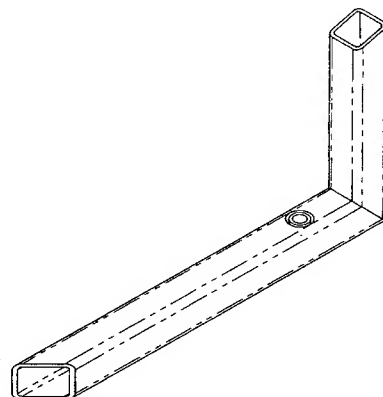
WA035

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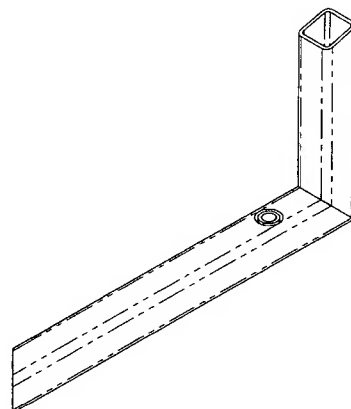
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6.0667

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84798 MLJ
12/05/23

RELEASED
08/11/23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

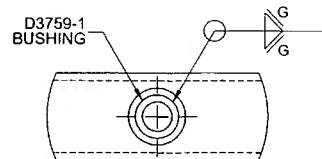
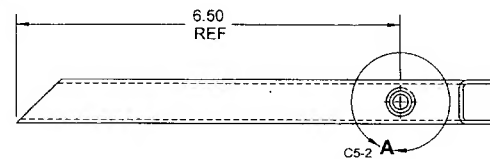
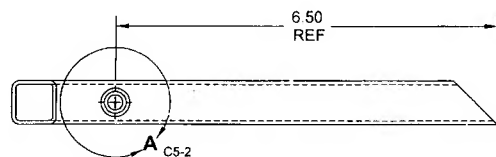
DRAWING NO. **D3838** REV. A

SHEET 1 OF 3

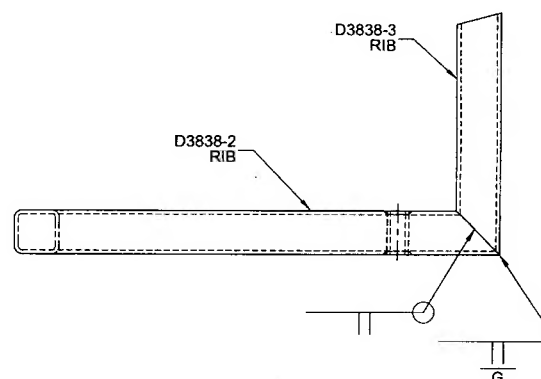
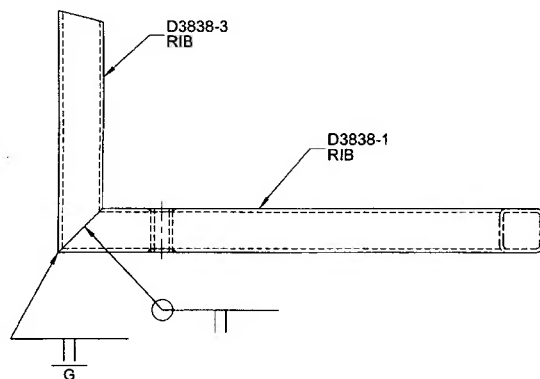
TITLE **RIB ASSY (BASKET LID)** SCALE: NTS

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DETAIL A
D2-2
D7-2 SCALE 2X

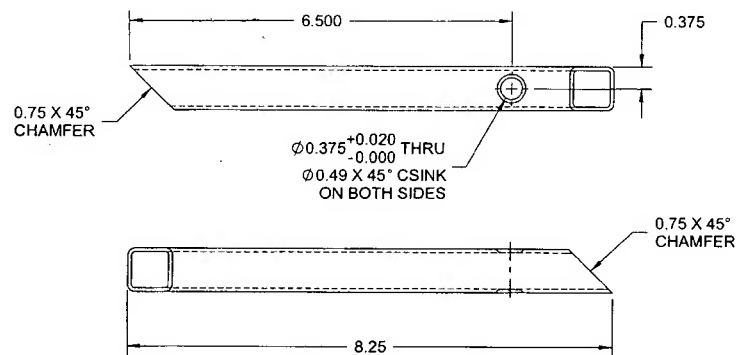


D3838-041 RIB ASSY (BASKET LID, LH)

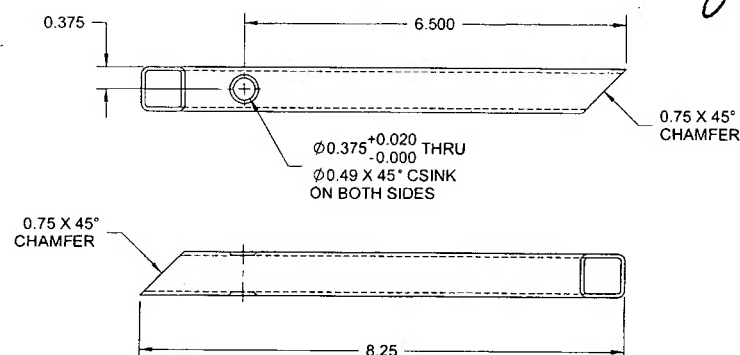
D3838-042 RIB ASSY (BASKET LID, LH)

RELEASED
08/10/08

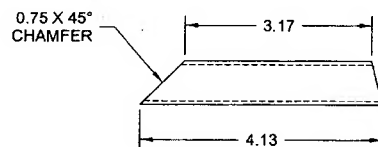
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
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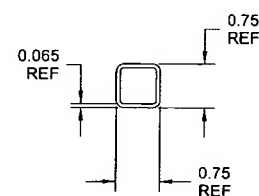
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

RELEASED
26/11/16 JH

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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